

Work Order ID 72114

Page 1

Tuesday, July 19, 2011 11:19:36 AM

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-07-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

IIN-D139-799

D

100

0.00



DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D139-799-013
CHG002

0.00

8 11/10/06

JG for MLJ 11-9-30

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/9/30 20 SL

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

8 11/10/06

②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 72114

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Page 2

Item ID: D139-799-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Cargo Door Hinge

Start Date: 7/19/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Packaging	0.00							
	Packaging								
	Memo Identify and pack for shipping as per PPP D139-799-013 Location: <u>So</u> PPP rev: <u>A</u>	0.00							
140 	QC21- Final Inspection - Work Order Release	0.00							
	QC								
	Quality Control								

11/10/11

PS

11/10/11

ME
11-10-06

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:19:42 AM

Page 1

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge



Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.08 new issue DD verf:JLM IPP REV:B
AS PER ECN 11-598 11-06-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Sr D2585 Mounting Channel		Manufactured	No			110	Each	75.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST017				75					
					69536			19					
					70814			56					
Sr D2586 Door Latch		Manufactured	No			110	Each	98.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST204				98					
					64774			48					
					70557			50					
Sr D2621 Latch Plate, 350 Spacepod		Manufactured	No			110	Each	34.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST019				34					
					56526			34					
Sr D3552-13 Door Prop		Manufactured	No			110	Each	11.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272A				11					
					56392			1					
					69668			10					

B73297 SP

B 73296 SP
2x

B73304 SP

B72101 11/10 SP (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:19:43 AM

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

D3622-1

Manufactured No

110 Each

36.0000

1 2



Ball Stud



Location

Loc Qty

Loc Code

ST070

36

67284

15

71540

21

D3622-3

Manufactured No

110 Each

42.0000

1 2



Ball Stud



Location

Loc Qty

Loc Code

ST070

42

52939

2

53951

40

D4072-1

Manufactured No

110 Each

0.0000

2 4



Airframe Hinge



D4072-3

Manufactured No

110 Each

24.0000

2 4



Airframe Hinge Backing Plate



Location

Loc Qty

Loc Code

ST119

24

71536

24

D4072-5

Manufactured No

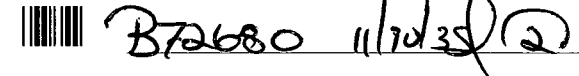
110 Each

27.0000

4 8



Bushing



Location

Loc Qty

Loc Code

ST119

27

62804

2

71537

25

W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, July 19, 2011 11:19:43 AM

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

D4073-1 Manufactured No

110 Each

0.0000

2 4



Door Hinge

D4073-3 Manufactured No

110 Each

22.0000

2 4



Door Hinge Backing Plate

Location

Loc Qty

Loc Code

ST120

22

65947

2

71541

20



B74242



B72108
B71269 (1*)

D4074-1 Manufactured No

110 Each

0.0000

1 2



Bracket

D4074-3 Manufactured No

110 Each

19.0000

1 2



Channel

Location

Loc Qty

Loc Code

ST120

19

62797

1

71543

18



B72109



B72403

D4074-5 Manufactured No

110 Each

0.0000

1 2



Backing Plate

D4074-7 Manufactured No

110 Each

1.0000

1 2



Striker Plate

Location

Loc Qty

Loc Code

ST120

1

62799

1



B71544 11/10/3



B72112 11/9/30 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Tuesday, July 19, 2011 11:19:43 AM

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

110

Each

1,618.000

20

40



Nut

Location

Loc Qty

Loc Code

ST300

1618

117441

786

117601

400

117885

432

MS21042L5

Purchased

No

110

Each

1,344.000

1

2



Nut

Location

Loc Qty

Loc Code

ST300

1344

116105

5

116548

155

117441

498

117591

100

117611

90

118179

496

MS27039-1-10

Purchased

No

110

Each

187.0000

8

16



Screw

Location

Loc Qty

Loc Code

ST290

150

117441

150

ST291

37

115935

37

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:19:44 AM

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-14 Purchased

No

110

Each

140.0000

2

4



Screw

Location

Loc Qty

Loc Code

MEZZ

140

112312

100

15924

40

MS27039-1-16 Purchased

No

Each

0.0000

16



Screw

MS27039-1-17 Purchased

No

110

Each

122.0000

1

2



Screw

Location

Loc Qty

Loc Code

ST292

122

11540

22

117591

100

NAS1149D0363J Purchased

No

110

Each

3,005.000

18

36



Washer

Location

Loc Qty

Loc Code

ST298

3005

117291

30

117505

500

117601

475

118077

2000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, July 19, 2011 11:19:44 AM

Work Order ID: 72114

Parent Item: D139-799-013

Parent Item Name: Cargo Door Hinge

Start Date: 7/19/2011

Required Date: 7/25/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0663J

Purchased

No

110

Each

639.0000

1

2



Washer



Handwritten: 11/9/30

Location

Loc Qty

Loc Code

ST298

639

115996

5

117291

134

117977

500

Handwritten: 2

NAS1515H5L

Purchased

No

110

Each

56.0000

4

8



WASHER



Handwritten: 11118614 11/9/30 (20)

Location

Loc Qty

Loc Code

FG

40

103691

40

ST277

16

111359

16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Qty -013	Part Number	Description
X	D139-799-013	CARGO DOOR HINGE KIT
1	D2585	MOUNTING CHANNEL
1	D2586	DOOR LATCH
1	D2621	LATCH PLATE
1	D3552-13	DOOR PROP
1	D3622-1	BALL STUD
1	D3622-3	BALL STUD
2	D4072-1	AIRFRAME HINGE
2	D4072-3	AIRFRAME HINGE BACKING PLATE
4	D4072-5	BUSHING
2	D4073-1	DOOR HINGE
2	D4073-3	DOOR HINGE BACKING PLATE
1	D4074-1	BRACKET
1	D4074-3	CHANNEL
1	D4074-5	BACKING PLATE
1	D4074-7	STRIKER PLATE
20	MS21042L3	NUT (or MS21042-3)
1	MS21042L5	NUT (or MS21042-5)
8	MS27039-1-10	SCREW
2	MS27039-1-14	SCREW
8	MS27039-1-16	SCREW
1	MS27039-1-17	SCREW
18	NAS1149D0363J	WASHER (or AN960JD10)
1	NAS1149D0663J	WASHER (or AN960JD616)
4	NAS1515H-5L	WASHER

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Revision: E
Date: 11.08.24